



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-251
Job Sheet 199303



Part No: D206-642-251

Job Qty: 1 pcs

Part Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/16/19

Job Tracking No:

Due Date: 9/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3804 REV A (DEO), IIN-D206-642 REV Q SHEETS 13,28 IPP REV:A 11.11.17 PER IIN REVO DD VERF;EC IPP Rev:B 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:C 14.04.25 ECN14-520 DD verf:JLM IPP Rev:D 16.04.04 as per CHG004(ecn16-553) DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1		9/3/19	0.00	3.00	Skidtubes - 1		00
		pcs					Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	1		9/3/19	0.00	0.00	QC 5 - 10		DAS AUG 22 2019 68 9-89
		pcs					QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	QC 9	1		9/3/19	0.00	0.00	QC 9 - 10		
		pcs					QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S207814



Part: D206-642-251

Job No: 199303

Serial No/Batch: S207814

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, ECN17-249, STC SH98 -

AUG 22 2019

50

0.90

140 Handfinish - 1-1 Chemical- B4B	1 pcs	9/3/19	0.00 1.05	QC 9 - 50	
				QC 9 - 9	
				Handfinish - 1 - 1 - B4B	BEB 19-08-23
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	9/3/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MLG
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	

					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	9/3/19	0.00 3.38		Skidtubes - 1 - B4B	00
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180 Skidtubes - 3 - B4B	1 pcs	9/3/19	0.00 3.38		Skidtubes - 1 - B4B	00
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
190 QC 5	1 pcs	9/3/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
200 Skidtubes - 4 - B4B	1 pcs	9/3/19	0.00 3.38		Skidtubes - 1 - B4B	00
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
220 QC 9	1 pcs	9/3/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	DAS
					QC 9 - 43	24
					QC 9 - 50	9-89
					QC 9 - 9	
230 QC 5	1 pcs	9/3/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	SEP 18 2019 68
					QC 5 - 50	9-89
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
240 Handfinish - 2-1 Pressure-B4B	1	9/3/19	0.00 1.05		Handfinish - 2 - 1 - B4B	
pcs					Handfinish - 2 - 2 - B4B	SEP 18 2019
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
250 Powdercoat - 1 White Gl(A)-	1	9/3/19	0.00 0.22		Powdercoat - 1 - B4B	
B4B M. 193989.	pcs				Powdercoat - 2 - B4B	
START: 9:55 OUT: 3:30 FINISH: 10:25					Powdercoat - 3 - B4B	BK 19-9-19.
260 QC 3	1	9/3/19	0.00 0.00		Powdercoat - 4 - B4B	
pcs					QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	KL 14-9-19
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
270 Handfinish - 4-1-Assembly-B4B	1	9/3/19	0.00 1.05		Handfinish - 4 - 1 - B4B	KL 19-9-20
pcs					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	

DAS
15
9-89

280 Handfinish - 4-2-Assembly-B4B	1 pcs	9/3/19	0.00 3.14	Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				Handfinish - 4 - 1 - B4B	16-9-2
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 QC 3	1 pcs	9/3/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
300 QC 5	1 pcs	9/3/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
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				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS SEP 20 2019 40
					QC 5 - 61	9-89
					QC 5 - 81	
310 Packaging 3-1 - Stock - B4B	1	9/3/19	0.00 0.00		Packaging 3 - 1 - B4B	
pcs					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS 21
					Packaging 3 - 36 - B4B	SEP 20 2019
315 DC - 1 - B4B	1	9/3/19	0.00 0.00		DC - 1 - B4B	
pcs					DC - 2 - B4B	
320 QC 21 - FG	1	9/3/19	0.00 0.00		QC 21 - FG - 21	DAS SEP 20 2019
pcs					QC 21 - FG - 70	21
Part Op 110 - Skid tubes - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld Descriptions: Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch A/R Aluminum Rod 138529/12701/ 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per dwg D3804 from front of tube and Deburr 6-Remove inner indexing ridge on Aft end of skid tube as per Dwg D3804 7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025. 8-Drill pilot holes using Dt 8167, including #30 pilot at 1.25" from 15.450". Most fwd x-bolt hole must be laid out manually at 78.04". 9-Locate DT8732A from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732B & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732A & doubler leaving DT8732B for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the s 120 - QC5- Inspect part completeness to step on W/O 130 - QC9- Inspect visual per QSI004- Fusion Welds 140 - Chemical Conversion Coat per QSI005 4.1 150 - QC7-Inspect Chemical Conversion Coat 160 - Skid tubes 1-Open holes to finished size to detail "B" as per Dwg D3804, (without cutting fluid) 2-C'sink ONE crossbolt spacer hole as per Dwg D3804 (Detail B)(without cutting fluid) 3-Deburr and blow out all chips from inside the						

tube

180 - Skid tubes - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting Start Date: _____ Time: _____

Finish Date: _____ Time: _____

Pick: Qty Part Number Description Batch A/R Sikaflex-291

Sikaflex expire date: 5/20/25 012516200

190 - QC5- Inspect part completeness to step on W/O

200 - Skid tubes 1-Remove alodine per DEO detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: Qty Part Number Description Batch A/R Aluminum Rod

138467 3-Grind welds flush as per Dwg D3804. 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. A/R SS Rod _____

5-Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002 6- Deburr

220 - QC9- Inspect visual per QSI004- Fusion Welds

230 - QC5- Inspect part completeness to step on W/O

240 - Pressure Wash per QSI005 4.3/ Clean and remove all markings

250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

260 - QC3- Inspect Part Finish

270 - HandFinish4 (Assemble as per dwg 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - HandFinish4 (Assemble as per dwg -1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R Sikaflex-291 5/20/25 Sikaflex expire date: 20.4.7 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: ML3 01-18

290 - QC3- Inspect Part Finish

300 - QC5- Inspect part completeness to step on W/O

310 - Identify and pack for shipping as per PPP D206-642-251 Location: _____ PPP Rev: _____

315 - Document Control Photocopy bluefile & type labels per PPP D206-642-251 CHG004

320 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation
D2620	Skid tube, 206 Skid tube	1 pcs (1 ea)	110-Skid tubes - 1
D2647	Cap	1 pcs (1 ea)	110-Skid tubes - 1
D3286-1	Doubler	2 pcs (2 ea)	110-Skid tubes - 1
CR3212-4-04	Cherry Rivet	<u>56</u> 52 Ea (52 ea)	200-Skid tubes - 4 - B4B
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skid tubes - 4 - B4B
D2654-3	Web	1 pcs (1 ea)	200-Skid tubes - 4 - B4B
D3286-3	Spacer	2 pcs (2 ea)	200-Skid tubes - 4 - B4B
D4720-1	Spacer	<u>20</u> 19 pcs (19 ea)	200-Skid tubes - 4 - B4B
AN3-37A	Bolt	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B
D2651-1	Plug	8 pcs (8 ea)	270-Handfinish - 4-1-Assembly-B4B
D2651-3	O-Ring	8 pcs (8 ea)	270-Handfinish - 4-1-Assembly-B4B
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B
D3805-043	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B
D3805-047	Run-on Landing Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B
D3873-1	Bushing <u>3209430(43)</u>	14 pcs (14 ea)	270-Handfinish - 4-1-Assembly-B4B
MS21042L3	Nut	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B
MS27039-1-08	Screw	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B
MS27039-4-06	Screw	1 Ea (1 ea)	270-Handfinish - 4-1-Assembly-B4B
NAS1149C0332R	Washer (AN960C10L)	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B
NAS1149D0332J	Washer	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B
NAS1149D0463J	Washer	1 Ea (1 ea)	270-Handfinish - 4-1-Assembly-B4B
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B
D2646	Aft Cap	1 pcs (1 ea)	280-Handfinish - 4-2-Assembly-B4B

Container

508952

5166018

5176117

516493x12

5176117

5176117

5176117

5210679

5196041

5180320

5197616

5213517

5214576

5204243.2

5162892

5166471

5193196

5178378

5156024

5099523

5147616

5215811

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	5	0
	D2647	1	30	0
	D3286-1	2	24	0
200-Skidtubes - 4 - B4B	CR3212-4-04	52	313	0
	D2649	1	31	0
	D2654-3	1	6	0
	D3286-3	2	8	0
	D4720-1	19	20	0
270-Handfinish - 4-1-Assembly-B4B	AN3-37A	7	77	0
	CCR264SS3-3	2	81	0
	CR3212-4-03	2	60	0
	D2651-1	8	305	0
	D2651-3	8	723	0
	D2680-041	1	32	0
	D3805-043	1	1	0
	D3805-047	1	1	0
	D3873-1	14	0	0
	MS21042L3	7	1,886	0
	MS27039-1-08	2	411	0
	MS27039-4-06	1	86	0
	NAS1149C0332R	7	2,894	0
	NAS1149D0332J	2	2,223	0
	NAS1149D0463J	1	3,760	0
280-Handfinish - 4-2-Assembly-B4B	D2646	1	67	0
Part Specifications				
Specifications could not be found.				

Plex 8/16/19 3:26 PM Dart.lajeunesse.marie

ITEM	Qty	Part Number	Description
1	X	D3804-041	SKIDTUBE ASSEMBLY, 208 A/B LOW
2	X	D3804-043	SKIDTUBE ASSEMBLY, 208 A/B HIGH
5	1	D2800-1-160	EXTRUSION
6	1	D2846	AFT CAP
7	1	D2847	CAP
8	18	D2849	CROSS BOLT SPACER
9	8	D2851-1	PLUG
10	8	D2851-3	O-RING
11	1	D2854-3	WEB
12	1	D2854-1	WEB
13	1	D2860-041	NUT PLATE
14	2	D3288-1	DOUBLER
15	2	D3288-3	STUD
21	2	AN960JD10L	WASHER
22	1	AN960JD418	WASHER
23	2	CCR264SS3-3	RIVET
24	2	CR3212-4-03	RIVET
25	52	CR3212-4-04	RIVET
26	2	MS27039-1-08	SCREW
27	1	MS27039-4-08	SCREW

NOTES

- 1) MATERIAL: W/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/281 ADHESIVE PER DART QSI 015
- 12) INSERT D2851-1 PLUG C/W D2851-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITH CHANGES

NO. 199303 MW
19-08-16

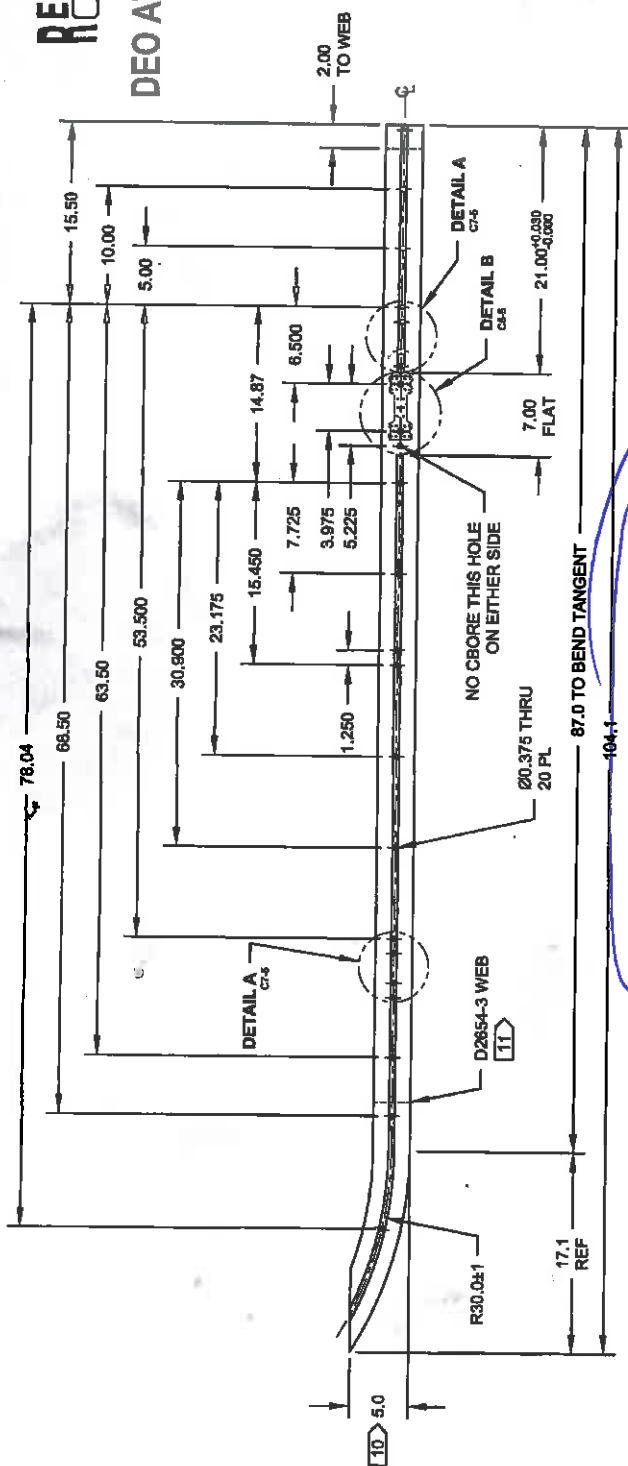
DEO ATTACHED

RELEASED
R 01-03-83
per E2N 01-576

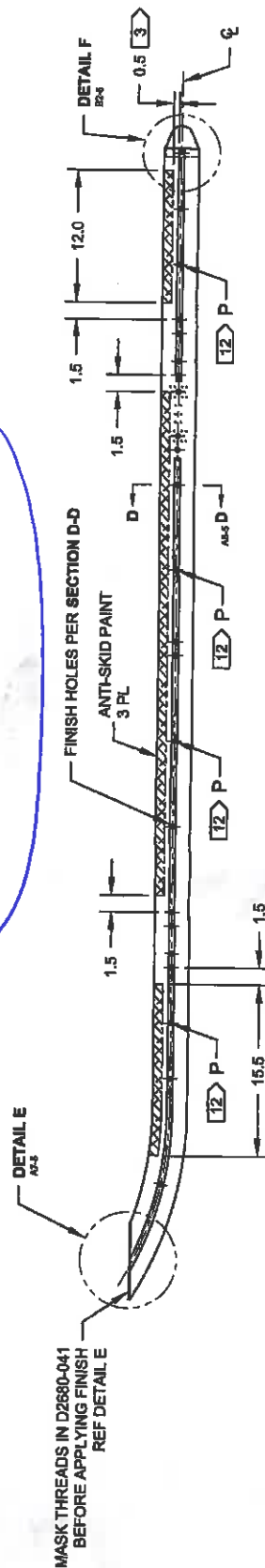
REV.	NEW ISSUE	DESCRIPTION	MB	BY	DATE
DESIGN	41	DART AEROSPACE USA, INC			08.07.07
DRAWN		PORT HADLOCK, WA			
CHECKED		DRAWING NO.			REV. A
MFG. APPR.		D3804			SHEET 1 OF 5
APPROVED		TITLE			SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 208A/B			NTS
DATE	08.07.07				

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DEO ATTACHED



D3804-043 BENDING/DRILLING DETAIL



DESIGN	01	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3804 REV. A SHEET 3 OF 5 SCALE NTS SKIDTUBE ASSEMBLY, 206A/B CONFIRMED & SENT BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED TO THE REMOTE CUSTOMER ONLY BY THE AUTHORITY OF DART AEROSPACE USA, INC. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	
DRAWN	1		
CHECKED	01		
MFG. APPR.	01		
APPROVED	01		
DATE	08.07.07	DE APPR.	01

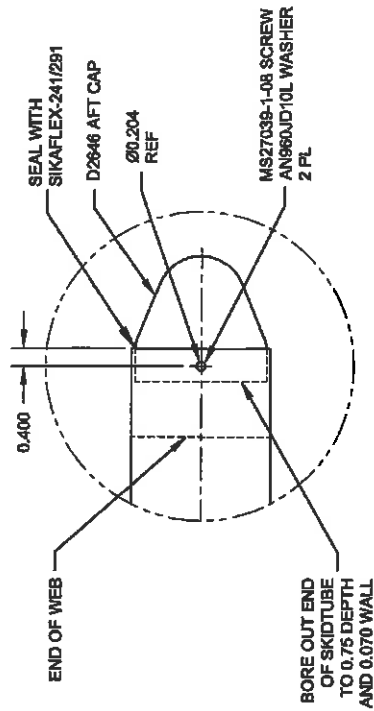
RELEASED

DEO ATTACHED

CR3212-4-03 RIVET
2 PL

CR284SS-3
RIVET
2 PL

VIEW G-G
SCALE NONE



DETAIL F
SCALE NONE

- D2847 CAP, TO INSTALL:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2847 (TRIM AS REQD)
 4. WELD D2847 IN PLACE
 5. GRIND FLUSH
 6. RIVET D2880-041 NUT PLATE IN PLACE

MS27038-4-08 SCREW
D2880-041
NUT PLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

DETAIL E
SCALE NONE

DESIGN	01	DART AEROSPACE USA, INC
DRAWN	1	PORT HADLOCK, WA
CHECKED	0	REV. A
MFG. APPR.	0	DRAWING NO. D3804
APPROVED	0	SHEET 5 OF 5
DATE	08.07.07	TITLE SKIDTUBE ASSEMBLY, 206A/B
		SCALE NTS

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering Water Jet Supplier Quality																																																																									
Part No. _____		Rework Scrap Use-as-is		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging																																																																									
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																																																																									
Description Work Order Deviation				Disposition																																																																											
Root Cause <table border="1"> <tr> <td>Operator</td><td></td> </tr> <tr> <td>Manufacturing Process</td><td></td> </tr> <tr> <td>Equip/Tooling</td><td></td> </tr> <tr> <td>Handling/Preservation</td><td></td> </tr> <tr> <td>Material</td><td></td> </tr> <tr> <td>Product Improvement</td><td></td> </tr> <tr> <td>Process Improvement</td><td></td> </tr> <tr> <td>Human Factors</td><td></td> </tr> </table>				Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td><td></td> <td>Contamination</td><td></td> <td>Power Loss/Surge</td><td></td> <td>Positioned Wrong</td><td></td> </tr> <tr> <td>Bending</td><td></td> <td>Misaligned/off center</td><td></td> <td>Folio/Program</td><td></td> <td>Outside Tolerance</td><td></td> </tr> <tr> <td>Crushing</td><td></td> <td>BOM/Route</td><td></td> <td>Grain Direction</td><td></td> <td>Drawing</td><td></td> </tr> <tr> <td>Cracks</td><td></td> <td>Broken/Damage/Defect</td><td></td> <td>Weld</td><td></td> <td>Finish</td><td></td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td></td> <td>Incomplete/Unclear Instructions</td><td></td> <td>Wrong Stock Pulled</td><td></td> <td>Part Lost/Missing</td><td></td> </tr> <tr> <td>Marks/Chatter</td><td></td> <td>Drill Holes</td><td></td> <td>Out of Sequence</td><td></td> <td>Misread</td><td></td> </tr> <tr> <td>Mislabeled</td><td></td> <td>Fit/Function</td><td></td> <td>Off-set/Set-up</td><td></td><td></td><td></td> </tr> </table>				Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong		Bending		Misaligned/off center		Folio/Program		Outside Tolerance		Crushing		BOM/Route		Grain Direction		Drawing		Cracks		Broken/Damage/Defect		Weld		Finish		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing		Marks/Chatter		Drill Holes		Out of Sequence		Misread		Mislabeled		Fit/Function		Off-set/Set-up			
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